Work Order ID 73827

Friday, September 16, 2011 11:39:22 AM

Item ID: D2651-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Plug

Start Date: 9/16/2011 **Start Qty:** 1,000.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 1,000.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Draw Nbr	Revision Nbr
D2651	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Hardinge CNC LATHE SMALL	0.00							
Hardinge	**Memo**	0.00							
Hardinge CNC Lathe Small	1- Turn as per Folio FA219 and Dwg D2651□2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00				1023	0	M	11/09/20
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00				1023	0	M	11/10/07
Powder Coating	(Only larger section necessary)☐START TIME: 9:30 ☐OVEN TEMPERATURE: 320 °F ☐FINISH TIME: 10:00								
M118439									
160	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00				1023	0	M	11/10/07
Quality Control						COUNT			

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: F-P A	0.00							
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10230 MF 11/10/07

11/10/11

MF 11-10-07

Picklist Print

Friday, September 16, 2011 11:39:19 AM

Work Order ID: 73827

Parent Item: D2651-1

Parent Item Name: Plug

Start Date: 9/16/2011 **Required Date:** 10/14/2011

Start Qty: 1,000.00 **Required Qty:** 1,000.00

Comments: IPP: A□02.04.15□New Issue□ NG□
IPP: B□05.12.12□added deburr EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 6061-T6 Round Bar .500"		Purchased	No			100	f	64.0220	0.0401	42.21053	11/9/22		

Location	Loc Qty	Loc Code
MAT012	64.022	
114488	4.322	
→ 117379	59.7	

50 ft

M6061T6R0.500
M117379

M6061T6R0.500
M117379

M6061T6R0.500
M117379

DART AEROSPACE LTD	Work Order:	73827
Description: Plug	**Part Number:**	**D2651-1**
Inspection Dwg: D2651 **Rev:** B		**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article** [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.060	—		Verm 7L-06	
0.375	+/-0.010	.375	—		"	
0.050 x 20°	+/-0.010	050 X20°	—		"	
Ø0.305	+0.000/-0.002	Ø.305	—		"	
Ø0.438	+/-0.005	Ø.439	—		"	
0.060	+/-0.005	.059	—		"	
0.090	+0.000/-0.002	.089	—		"	
0.045	+0.000/-0.002	.044	—		"	

Measured by:	[signature]	Audited by:	D.A	Prototype Approval:	N/A
Date:	11/09/21	Date:	11/09/23	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	

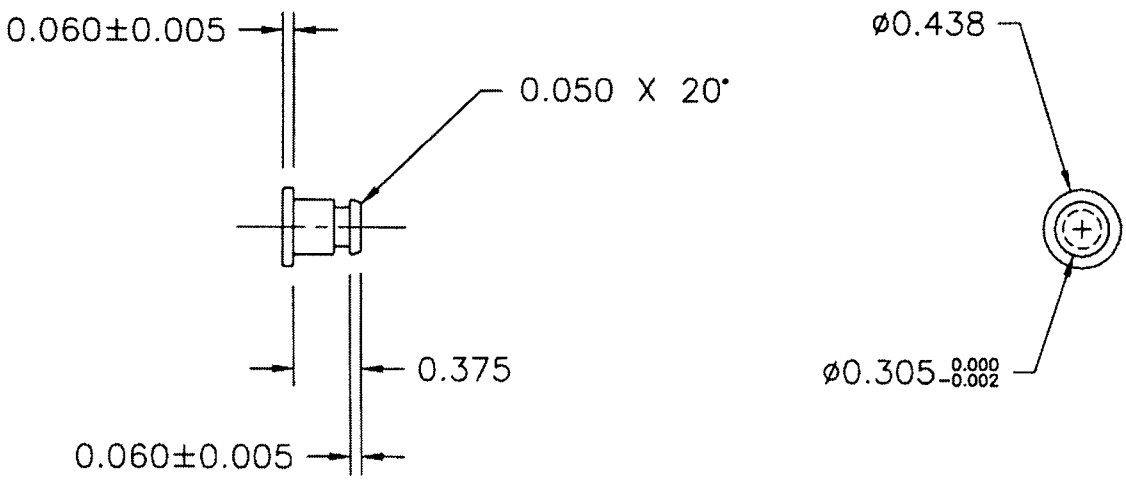
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1

A	97.03.25	NEW ISSUE
B	03.12.19	ADD POWDER COAT, MS28775-008

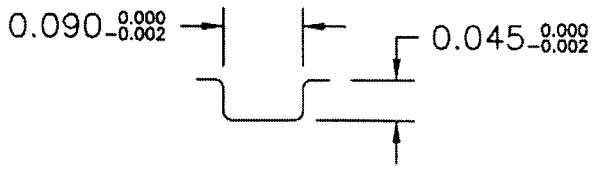
RELEASED
03.12.19

13827

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
   POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

1) MATERIAL: BUNA N, 70 DUROMETER
   3/16 ID, 5/16 OD, 1/16 WIDTH
   (PARKER 2-008, MS28775-008 OR EQUIVALENT)

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